

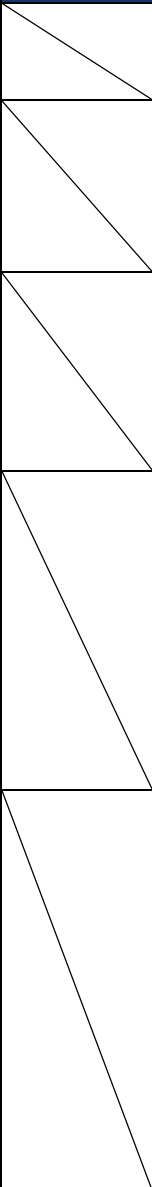
	REGISTRO <i>RECORD</i>			REVISÃO <i>REVISION</i>	1
	FICHA DE SERVIÇOS <i>Service Sheet</i>			PAGINA <i>PAGE</i>	1/6
CODIGO CODE IAS-RG-0223	OS	MODELO Model AILERON ACTUATOR	PN 2524667	SN	

IDENTIFICAÇÃO / IDENTIFICATION

TÍTULO FICHA DE REGISTRO DE INSPEÇÃO <i>TITLE</i> <i>INSPECTION RECORD SHEET</i>

PUBLICAÇÃO PUBLICATION TECHNICAL MANUAL OVERHAUL INSTRUCTIONS	REFERÊNCIA REFERENCE T.O 9H2-4-111-3	TLN TLN001737	DATA DATE REVISÃO 11 DE 15/02/2015
		PN	CONJUNTO MAIOR MAIN PART SN

TAREFAS / TASKS

Item (Item):	PN:	SN:	Nomeclatura (Nomeclature):		
Item <i>Item</i>	Procedimentos <i>Procedures</i>	Critério <i>Criteria</i>	Resultado <i>Result</i>	Condição <i>Condition</i>	Realizado por: <i>Performed by</i>
Table 3-1 Index No. 4	VISUAL Face Seal Plate	Cleanness and condition of holes and surfaces		☐ OK ☐ NOK	
Table 3-1 Index No. 13	VISUAL Screw (CSI)	Corroded, worn or distorted screw. Cleanness and condition of threads.		☐ OK ☐ NOK	
Table 3-1 Index No. 14	VISUAL Lever (CSI)	Damaged Serrations. Distorted lever. Condition of stop surfaces.		☐ OK ☐ NOK	
Table 3-1 Index No. 16	VISUAL Crank Bearing (Crank and Crank Bearing are a matched set)	Cleanness and condition of threads. Smoothness of internal bearing surfaces. Damaged wrench flats. Condition of cadmium plating.		☐ OK ☐ NOK	
Table 3-1 Index No. 17	VISUAL Crank Bearing (Crank and Crank Bearing are a matched set). (CSI)	Cleanness and condition of threads, serrations. Condition of plated surfaces. Worn, bent, distorted or damaged ball end. Scored, pitted or worn bearing surface on crank shaft.		☐ OK ☐ NOK	
Item	Procedimentos	Critério	Resultado	Condição	Realizado por:

	REGISTRO <i>RECORD</i>	REVISÃO 1 REVISION
CODIGO CODE IAS-RG-0223	FICHA DE SERVIÇOS <i>Service Sheet</i>	PAGINA 2/6 PAGE

Item	Procedures	Criteria	Result	Condition	Performed by
Table 3-1 Index No. 22	VISUAL Valve Retainer Nut	Cleanness and condition of threads, slots, and safety holes		☐ OK ☐ NOK	
Table 3-1 Index No. 24	VISUAL Servovalve (CSI)	Inspect in accordance with instructions in applicable overhaul manual		☐ OK ☐ NOK	
Table 3-1 Index No. 29	VISUAL Strainer	Cleanness and condition of strainer holes.		☐ OK ☐ NOK	
Table 3-1 Index No. 30	VISUAL Filter element	Cleanness and condition of threads, screen, and safety holes Damaged wrench flats. Condition of plating.		☐ OK ☐ NOK	
Table 3-1 Index No. 32	VISUAL Relief Valve	Cleanness and condition of threads, inlet and outlet holes, and safety holes. Damaged wrench flats. Condition of plating.		☐ OK ☐ NOK	
Table 3-1 Index No. 36	VISUAL Manifold	Cleanness and condition of threads and hydraulic fluid passages Nicked, cracked, burred, or corroded Seal inserts 2-43171- 1. (Seal inserts are not used on some actuators.)		☐ OK ☐ NOK	
Table 3-1 Index No. 37	VISUAL Rod-End Bearing	Cleanness and condition of threads, keyway, and lubrication passages Binding, drag, or excessive axial or radial play of bearing inner race. Condition of plated surfaces.		☐ OK ☐ NOK	
Table 3-1 Index No. 40	VISUAL Bushing Retainer	Cleanness and condition of threads, slots and safety holes Condition of plating.		☐ OK ☐ NOK	

	REGISTRO <i>RECORD</i>	REVISÃO 1 REVISION
CODIGO CODE IAS-RG-0223	FICHA DE SERVIÇOS <i>Service Sheet</i>	PAGINA 3/6 PAGE

Item <i>Item</i>	Procedimentos <i>Procedures</i>	Critério <i>Criteria</i>	Resultado <i>Result</i>	Condição <i>Condition</i>	Realizado por: <i>Performed by</i>
Table 3-1 Index No. 41	VISUAL Piston	Cleanness and condition of threads and ring groove Damaged wrench flats and locking slots on end of shaft Condition of plated surfaces.		☐ OK ☐ NOK	
Table 3-1 Index No. 42	VISUAL Bushings	Cleanness and condition of hydraulic fluid passages and oil hole Smoothness of internal surfaces. Conditions of plating		☐ OK ☐ NOK	
Table 3-1 Index No. 52	VISUAL Sleeve	Cleanness and condition of slots. Smoothness of bore.		☐ OK ☐ NOK	
Table 3-1 Index No. 60	VISUAL Identification Plate Unique identification Label	Legibility. Missing/damaged UII		☐ OK ☐ NOK	
Table 3-1 Index No. 62 and 63	VISUAL Screw thread insert (Installed)	Cleanness and condition of inserts		☐ OK ☐ NOK	
Figure 3-1 Index No. 64	VISUAL Actuator Body	Cleanness and condition of threads, hydraulic fluid passages, and vent holes Smoothness of cylinder bores Condition of lacquered surfaces.		☐ OK ☐ NOK	
Figure 3-1 Index No. 16	INSPEÇÃO DIMENSIONAL Crank Bearing Internal bore diameter	Matched with Crank (17) for 0.0004 to 0.0007 inch clearance		☐ OK ☐ NOK	
Figure 3-1 Index No. 16	INSPEÇÃO DIMENSIONAL Crank Bearing packing groove diameter	0.422" – 0.424"		☐ OK ☐ NOK	
Figure 3-1 Index No. 17	INSPEÇÃO DIMENSIONAL Crank (CSI) Ball	0.1886"-0.1888"	VALOR NCC	☐ OK ☐ NOK	

	REGISTRO <i>RECORD</i>	REVISÃO <i>REVISION</i> 1
CODIGO CODE IAS-RG-0223	FICHA DE SERVIÇOS <i>Service Sheet</i>	PAGINA <i>PAGE</i> 4/6

Item <i>Item</i>	end diamenter Procedimentos <i>Procedures</i>	Critério <i>Criteria</i>	Resultado <i>Result</i>	Condição <i>Condition</i>	Realizado por: <i>Performed by</i>
Figure 3-1 Index No. 17	INSPEÇÃO DIMENSIONAL Crank (CSI) shaft diamenter	Matched with Crank Bearing (16) for 0.0004 to 0.0007 inch clearance	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 17	INSPEÇÃO DIMENSIONAL Crank (CSI) Maximum serration diameter	0.307" - 0.308"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 24	INSPEÇÃO DIMENSIONAL Servo valve (CSI) Inside diameter of hole in slide	0.1889" - 0.1891"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 37	INSPEÇÃO DIMENSIONAL Rod-End Bearing Bearing inside diameter	0.4995" – 0.5000"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 41	INSPEÇÃO DIMENSIONAL Piston Shaft diameter	0.9965" - 0.9975"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 41	INSPEÇÃO DIMENSIONAL Piston Head diameter	2.1210"- 2.1220"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 41	INSPEÇÃO DIMENSIONAL Piston Ring groove width	0.125"- 0.127	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 42	INSPEÇÃO DIMENSIONAL Bushing Outside diameter	2.371" - 2.373"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 42	INSPEÇÃO DIMENSIONAL Bushing Inside diameter	1.000"- 1.002"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 42	INSPEÇÃO DIMENSIONAL Bushing Piston shaft packing groove diameter	1.240" - 1.242"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 42	INSPEÇÃO DIMENSIONAL Bushing Hydraulic seal diameter	1.240" - 1.242"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 43	INSPEÇÃO DIMENSIONAL Rod Seal Retainer Ring Inside diameter	1.000"- 1.002"	VALOR NCC	☐ OK ☐ NOK	
Figure 3-1 Index No. 52	INSPEÇÃO DIMENSIONAL Sleeve Bore diameter	2.125" - 2.127"	VALOR NCC	☐ OK ☐ NOK	

	REGISTRO <i>RECORD</i>	REVISÃO <i>REVISION</i> 1
CODIGO CODE IAS-RG-0223	FICHA DE SERVIÇOS <i>Service Sheet</i>	PAGINA <i>PAGE</i> 5/6

Item <i>Item</i>	Procedimentos <i>Procedures</i>	Critério <i>Criteria</i>	Resultado <i>Result</i>	Condição <i>Condition</i>	Realizado por: <i>Performed by</i>
Figure 3-1 Index No. 4	ENSAIOS Plate	FPI conforme norma ASTM E1417	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 16	ENSAIOS Bearing	Partícula magnética conforme norma ASTM E1444	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 17	ENSAIOS Crank	Partícula magnética conforme norma ASTM E1444	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 22	ENSAIOS Retainer nut	FPI conforme norma ASTM E1417	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 36	ENSAIOS Manifold	FPI conforme norma ASTM E1417	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 40	ENSAIOS Retainer	Partícula magnética conforme norma ASTM E1444	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 41	ENSAIOS Piston	Partícula magnética conforme norma ASTM E1444	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 42	ENSAIOS Bushing	FPI conforme norma ASTM E1417	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 43	ENSAIOS Retaining Ring	FPI conforme norma ASTM E1417	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 52	ENSAIOS Sleeve	Partícula magnética conforme norma ASTM E1444	OS LAUDO	☐ OK ☐ NOK	
Figure 3-1 Index No. 64	ENSAIOS Body	FPI conforme norma ASTM E1417	OS LAUDO	☐ OK ☐ NOK	

	REGISTRO <i>RECORD</i>	REVISÃO <i>REVISION</i> 1
CODIGO CODE IAS-RG-0223	FICHA DE SERVIÇOS <i>Service Sheet</i>	PAGINA <i>PAGE</i> 6/6

OBSERVAÇÕES / REMARKS

Aprovador por: <i>Approved by</i>	I	Data: <i>Date</i>
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RELAÇÃO DE RELATÓRIO / JOB REPORT								
Responsável (Responsible)	Data (Date)	Folha (Sheet paper)	Nº Pag. (Page nº)		Responsável (Responsible)	Data (Date)	Folha (Sheet paper)	Nº Pag. (Page nº)